

Date  
UserTuesday, 8/28/2007 3:23:20 PM  
Kim Johnston

## Process Sheet

w/lo  
SB 07/11/13

|                       |   |                  |               |
|-----------------------|---|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services               | Drawing Name     | : ARM         |
| Job Number            | : 34321 -2  |                  |               |
| Estimate Number       | : 12973   | Part Number      | : D36461      |
| P.O. Number           | : N/A   | Drawing Number   | : D3646 REV.A |
| This Issue            | : 8/28/2007   | Project Number   | : N/A         |
| Prsht Rev.            | : NC  | Drawing Revision | : A           |
| First Issue           | : N/A   | Material         | : N/A         |
| Previous Run          | : N/A   | Due Date         | : 9/28/2007   |
| Written By            | :   | Qty:             | 10 Um: Each   |
| Checked & Approved By | : <u>John 0828</u>                                  |                  |               |
| Comment               | : Est Rev. A new issue 07.07.25 EC verified by: JLM |                  |               |

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.0790 f(s)/Unit Total: 20.7900 f(s)  
Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall (M304TR0.500W.035)

Batch: M 106015

SB 07/11/14 (9)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch to length as per Dwg D3646 &amp; template DT8958

SB 07/11/14 (9)

3.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

SB 07/11/14 (9)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/11/14 (x5) counter

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR 07-11-21(9)

| W/O:     |      | WORK ORDER CHANGES |    |          |     |                                     |                          |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 07/10/18 | 1    | Split W/O          | SB | 07/11/18 | 9   |                                     |                          |
|          |      |                    |    |          |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Tuesday, 8/28/2007 3:23:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34321

Part Number: D36461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*6/7/11/21 (9)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SI 266*

*P*

*AS 07/11/21*

*(94)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(9)*  
*7/07/11/22*

Job Completion



*W 07.11.21*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

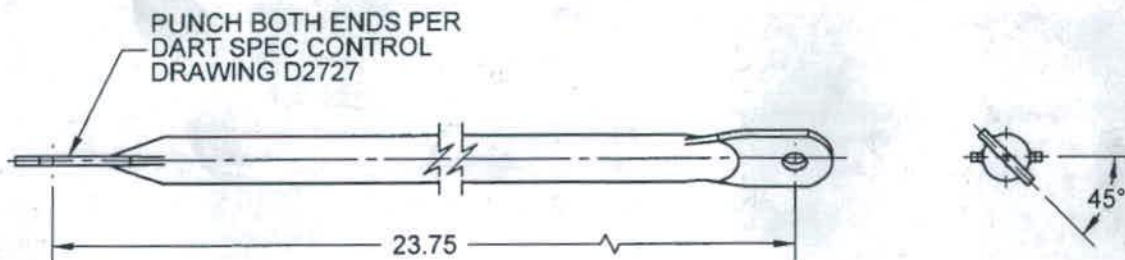
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                         |                       |  |                        |
|-------------------------|-----------------------|--|------------------------|
| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i>  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>PH</i> | DRAWING NO.<br><b>D3646</b>                              | REV. A<br>SHEET 1 OF 2 |
| DATE<br><b>07.06.06</b> |                       | TITLE<br><b>ARM</b>                                      | SCALE<br>1:2           |
| REV<br>A                | DATE<br>07.06.06      | DESCRIPTION<br>NEW ISSUE                                 |                        |

**RELEASED**07.07.11 *PH*

24.580

**D3646-1 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 0054.9
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34321**

COPYRIGHT © 2007 BY DART AEROSPACE LTD

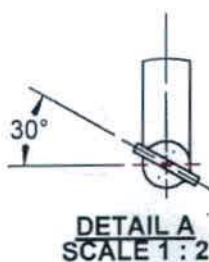
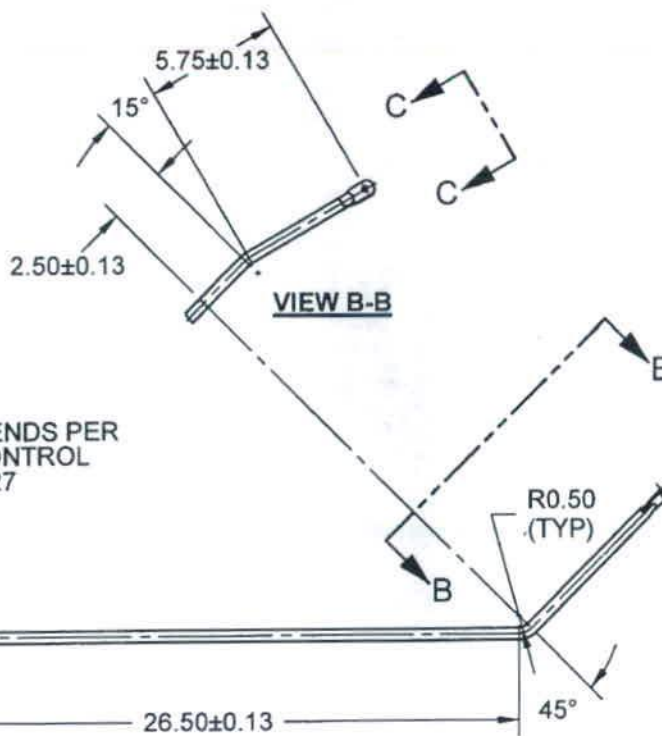
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



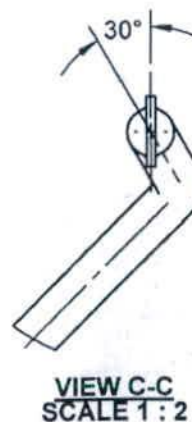


**DART**

|                         |                                |  |                        |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i>           | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3646</b>                              | REV. A<br>SHEET 2 OF 2 |
| DATE<br><b>07.06.06</b> |                                | TITLE<br><b>ARM</b>                                      | SCALE<br>1:8           |



**RELEASED**  
07.07.11 *[Signature]*



### **D3646-3 ARM**

#### **NOTES:**

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34321**

**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

